

G6845247

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



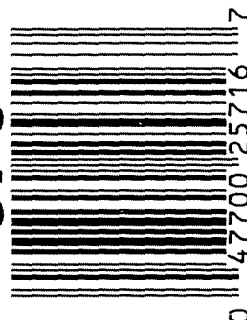
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6845247

UPC



BM FORM

GUN SERIAL # G 6845247

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-17-09	SP
430	ASSEMBLE TO STOCK		3-17-09	RP
440	PROOF		3-17-09	SP
460	CHECK HEADSPACE		3-17-09	SP
470	DIS-ASSEMBLE ACTION		3-17-09	SP
472	SERIALIZE BOLT HANDLE		3-18-09	K12
475	DRILL AND TAP SIGHT HOLES		3-18-09	SP
480	MAGNAFLUX BBL ACTION	①	3/20/09	①
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/24/09	RT
520	GOFF BLAST BBL / REC		3-24	BT
542	APPLY COATINGS (BARREL ACTION)		3-28	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-31-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-31-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-31-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-9-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

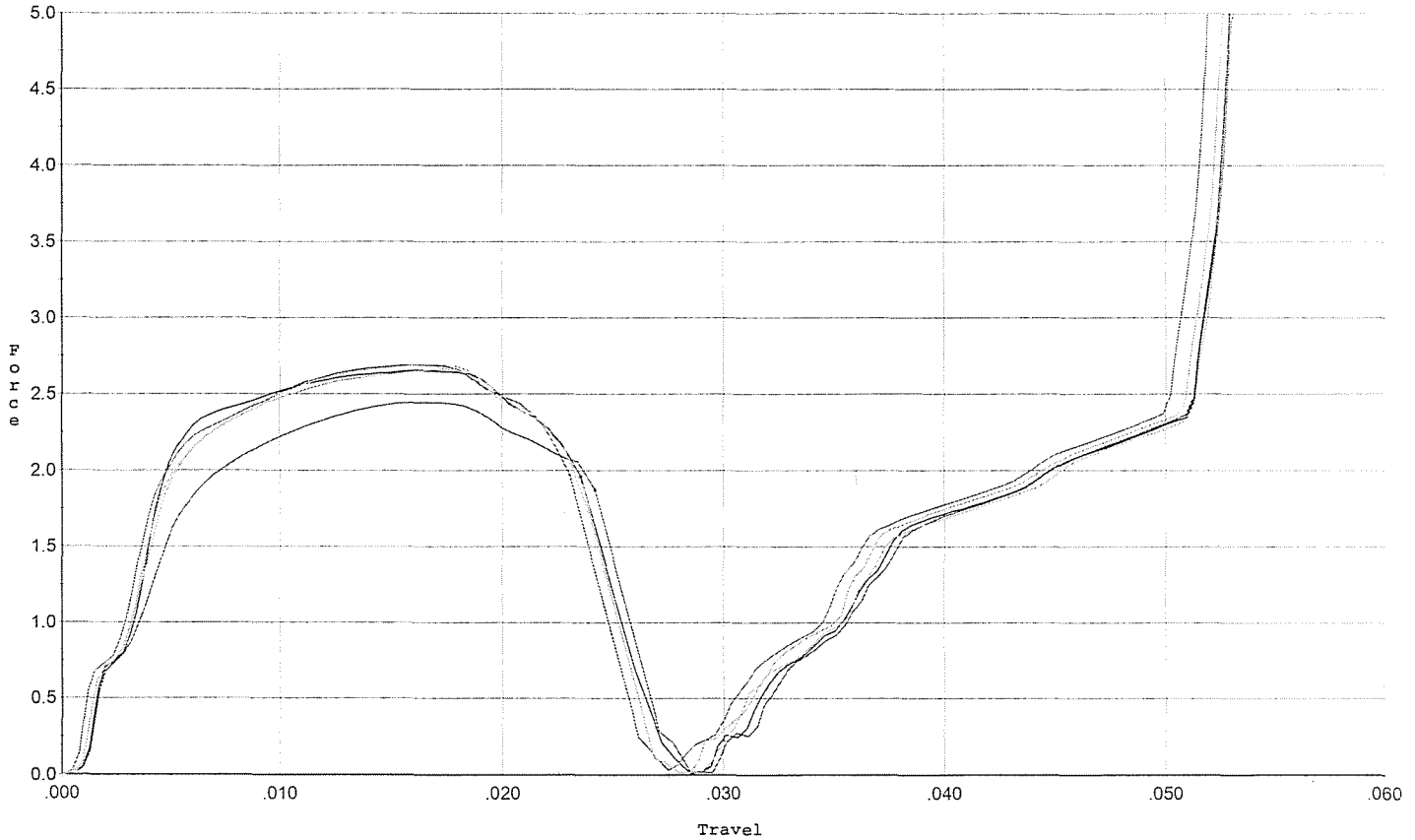
F004 REV 5/2006

560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>7</u> <u>4.5</u> <u>6.5</u>	<u>4-17-09</u>	<u>WW</u>
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	<u>4-17-09</u>	<u>WW</u>
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.022</u> <u>.023</u> <u>.023</u>	<u>4-17-09</u>	<u>WW</u>
	J) ASSEMBLE STOCK			<u>4-9-09</u>	<u>RP</u>
	K) ASSEMBLE SWIVEL STUDS			<u>4-17-09</u>	<u>WW</u>
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				
	M) IRON SIGHT ALIGNMENT				
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				
640 & 650	FUNCTION TEST AND TARGET		<u>PASS</u> FAIL <u>PASS</u> FAIL	<u>4-14-09</u>	<u>RP</u>
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
660	INSPECT FOR LIVE AMMO			<u>4-14-09</u>	<u>RP</u>
670	FINAL INSPECTION A) HEADSPACE			<u>4-17-09</u>	<u>WW</u>
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>246</u> <u>253</u> <u>237</u> <u>262</u> <u>248</u>	<u>4-15-09</u>	<u>RP</u>
	C) FUNCTION			<u>4-17-09</u>	<u>WW</u>
690	PACK			<u>5/30/09</u>	<u>FM</u>

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs ini +/- .50 lb



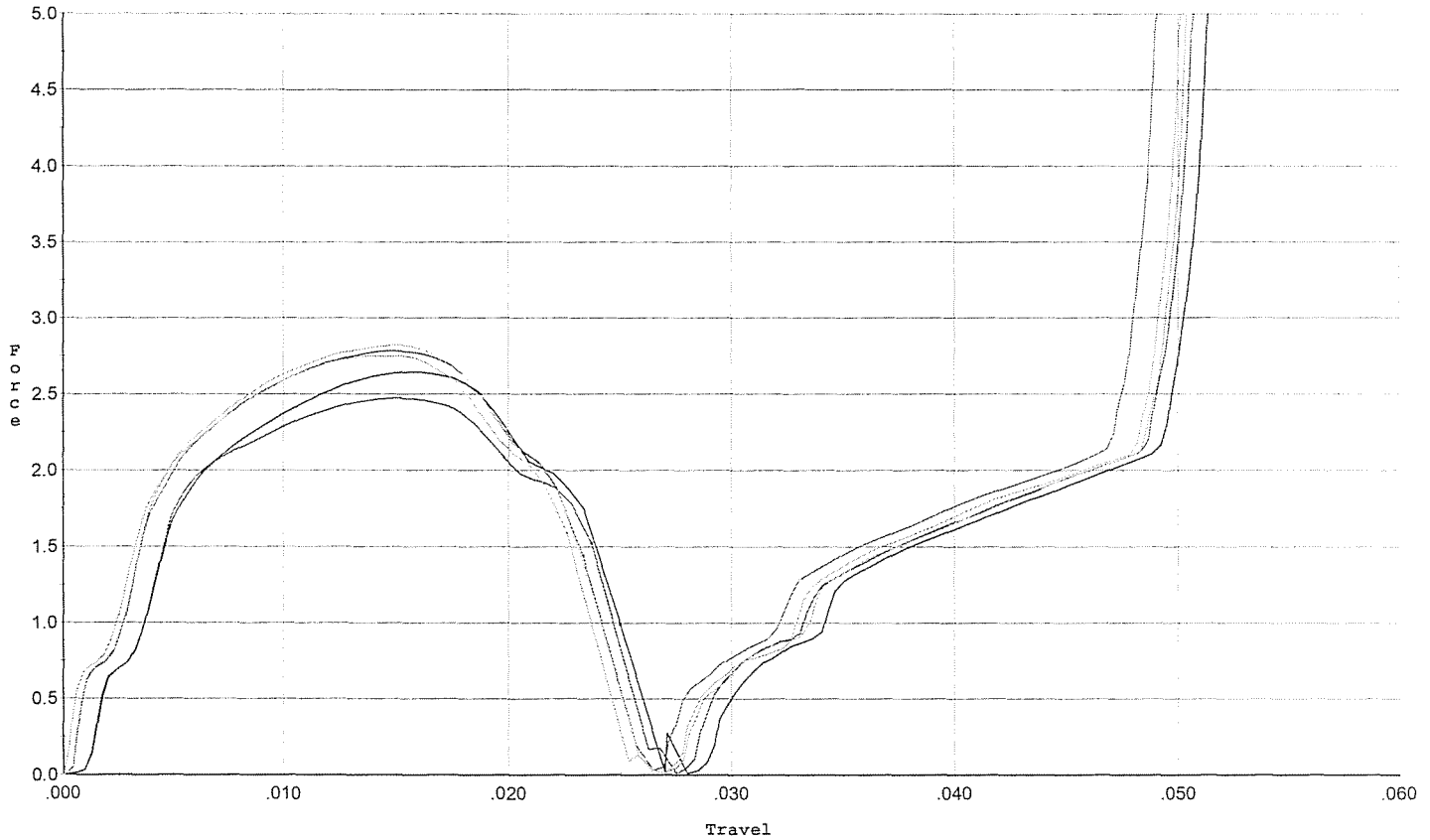
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.444	0.024	0.00	0.035	0.044		Set Trigger
2	2.651	0.024	0.00	0.035	0.048		Set Trigger
3	2.688	0.023	0.00	0.034	0.047		Set Trigger
4	2.692	0.024	0.00	0.035	0.048		Set Trigger
5	2.663	0.024	0.00	0.035	0.047		Set Trigger

A-2-62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs after 50 cycles+/- .50 lb



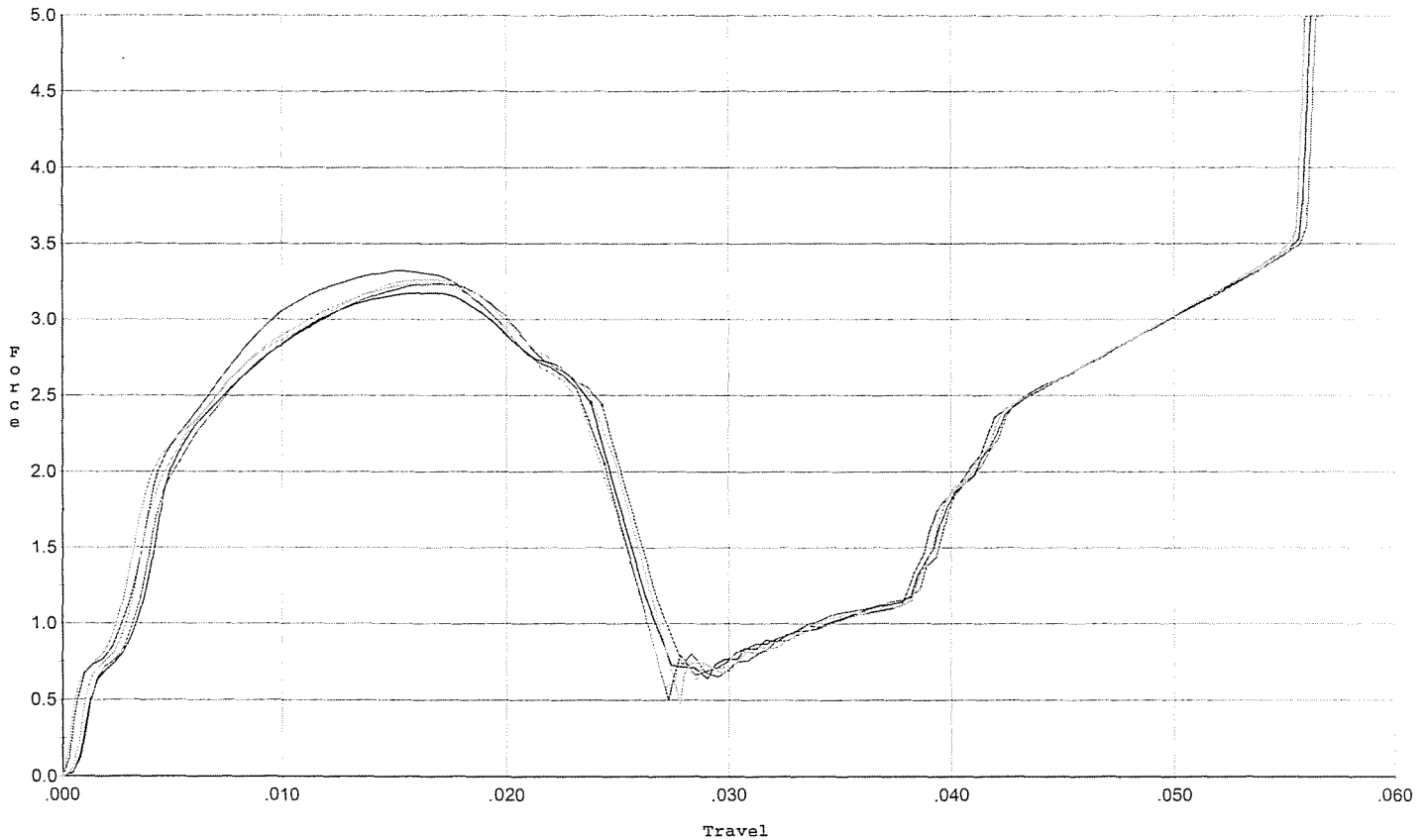
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.471	0.024	0.00	0.033	0.042		Set Trigger
2	2.643	0.025	0.00	0.033	0.046		Set Trigger
3	2.783	0.023	0.00	0.032	0.047		Set Trigger
4	2.821	0.023	0.00	0.033	0.048		Set Trigger
5	2.750	0.023	0.00	0.033	0.046		Set Trigger

A-2-69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs ini +/- .75 lb



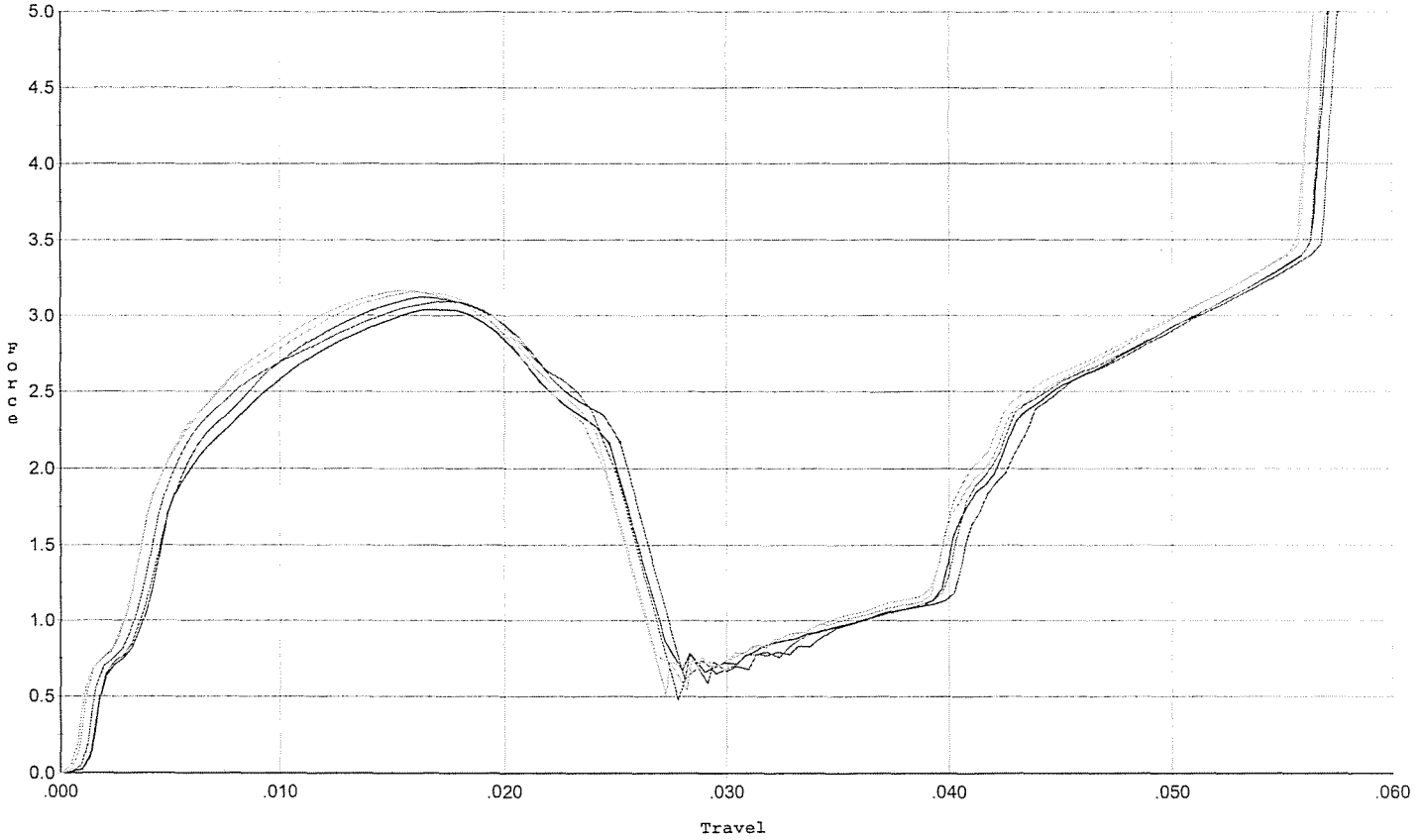
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.321	0.024	0.00	0.036	0.059		Set Trigger
2	3.174	0.024	0.00	0.037	0.054		Set Trigger
3	3.231	0.024	0.00	0.036	0.056		Set Trigger
4	3.264	0.025	0.00	0.036	0.058		Set Trigger
5	3.243	0.025	0.00	0.036	0.058		Set Trigger

A-3-24

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs after 20 cycles+/- .75 lb



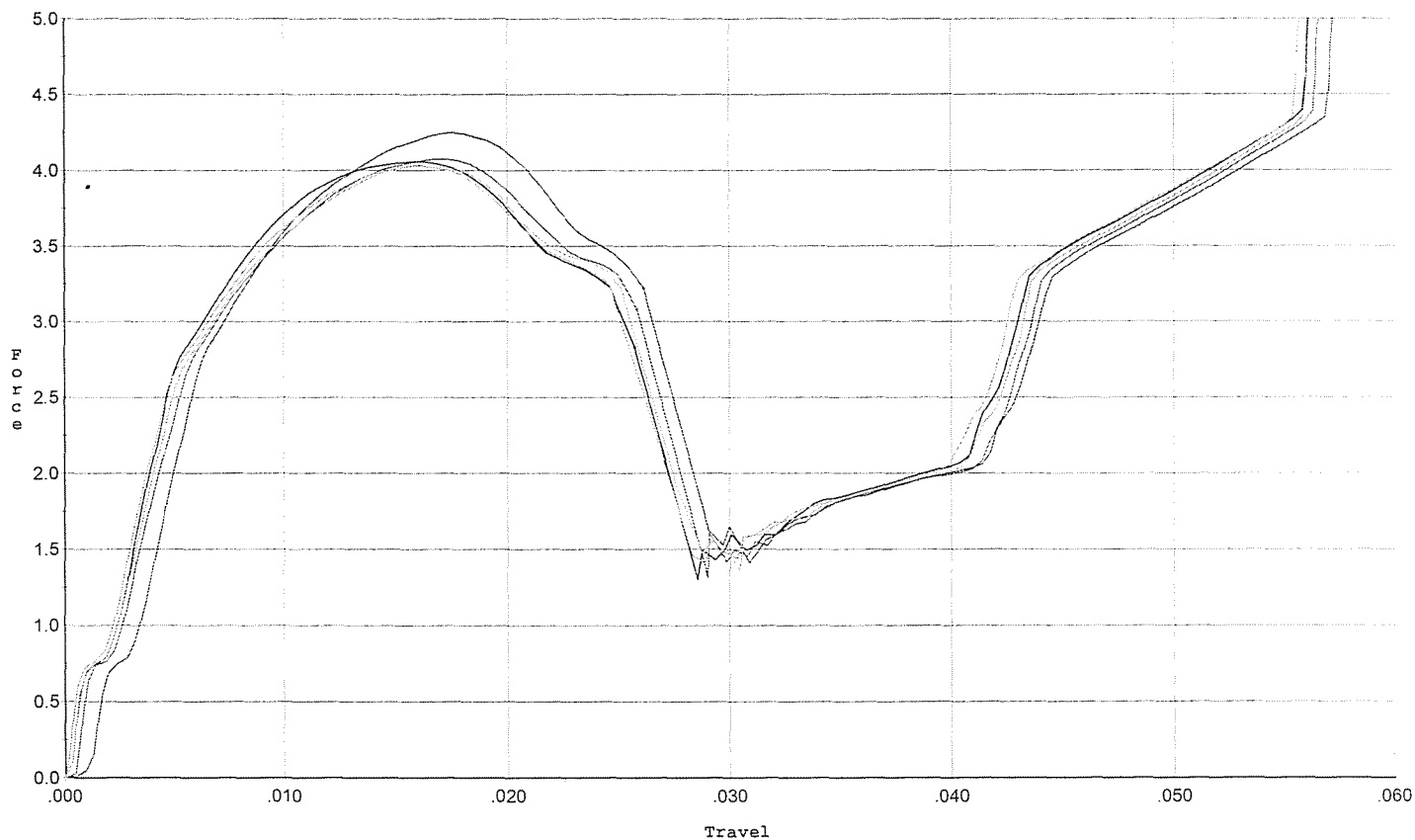
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.123	0.025	0.00	0.037	0.055		Set Trigger
2	3.039	0.025	0.00	0.037	0.052		Set Trigger
3	3.095	0.025	0.00	0.037	0.055		Set Trigger
4	3.154	0.024	0.00	0.037	0.055		Set Trigger
5	3.166	0.024	0.00	0.037	0.056		Set Trigger

A-3-11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs ini +/- 1.0 lb



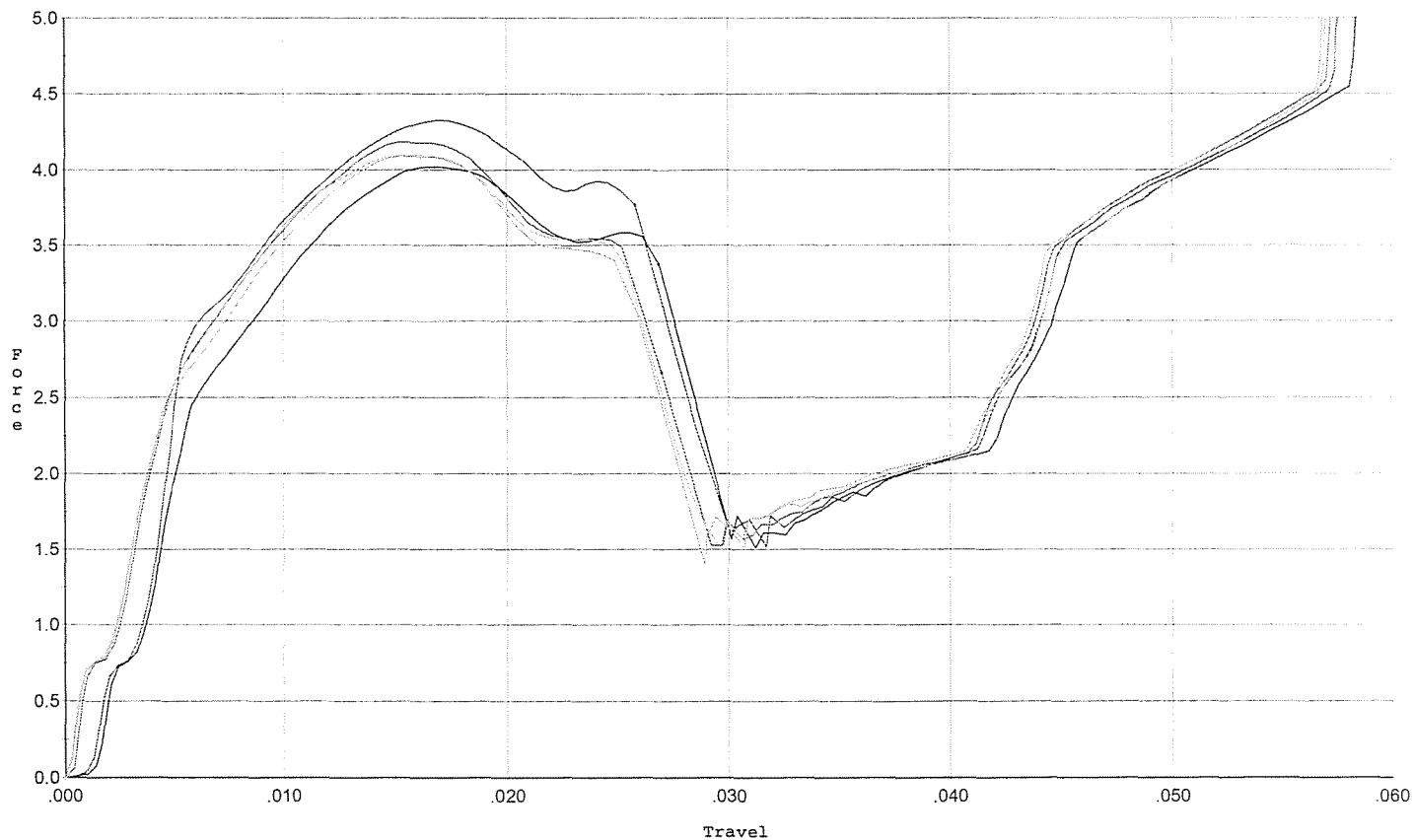
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.249	0.026	0.00	0.033	0.076		Set Trigger
2	4.058	0.026	0.00	0.033	0.075		Set Trigger
3	4.076	0.026	0.00	0.033	0.075		Set Trigger
4	4.040	0.025	0.00	0.033	0.073		Set Trigger
5	4.031	0.026	0.00	0.033	0.077		Set Trigger

A-4.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs after 20 cycles+/- 1.0 lb



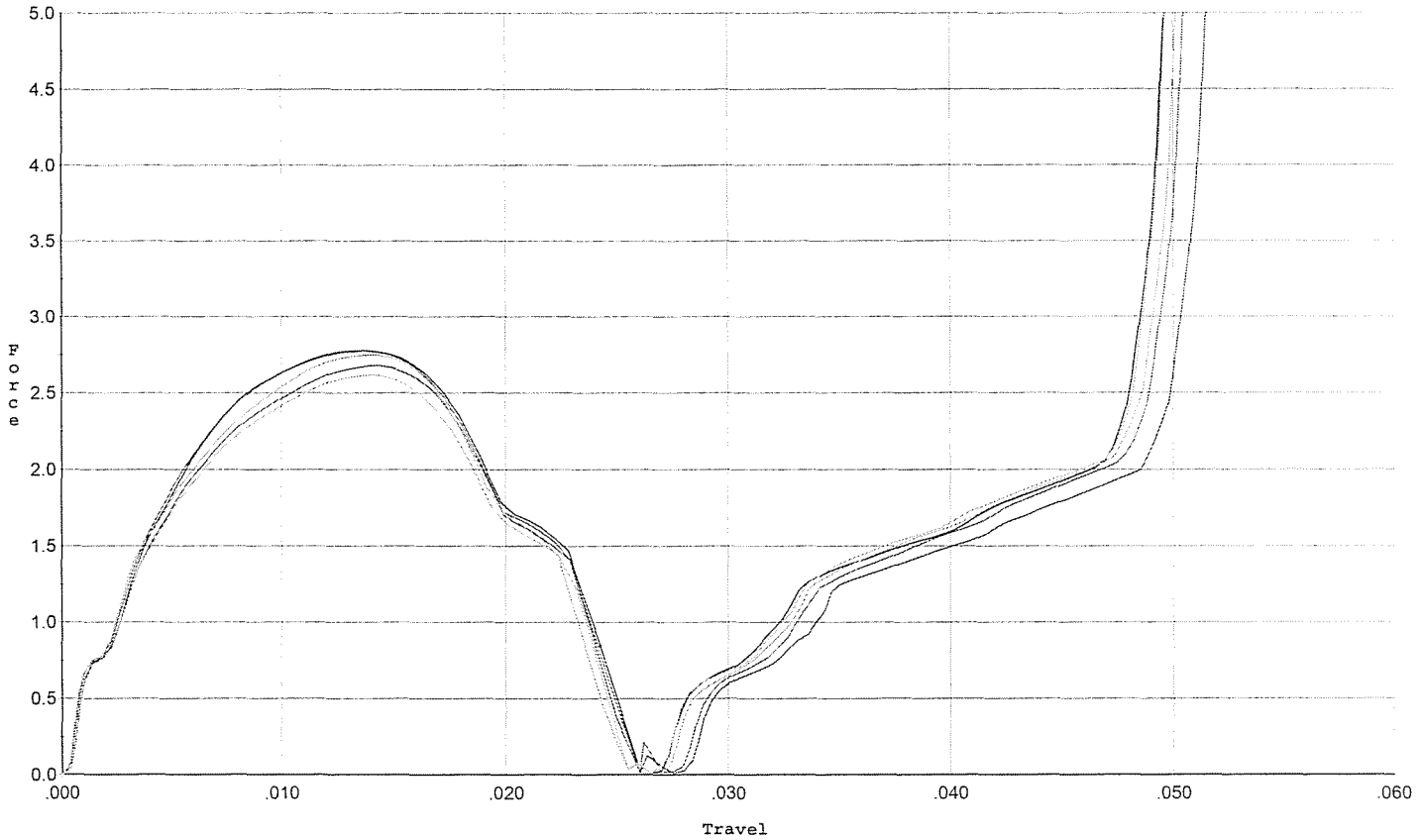
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.327	0.026	0.00	0.033	0.078		Set Trigger
2	4.020	0.027	0.00	0.033	0.075		Set Trigger
3	4.181	0.027	0.00	0.033	0.080		Set Trigger
4	4.094	0.025	0.00	0.033	0.075		Set Trigger
5	4.096	0.026	0.00	0.033	0.076		Set Trigger

A-4.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

Model: M/24
Serial No: Form #F005
Trigger: reset to 2.5 lbs +/- .50 lb for final test



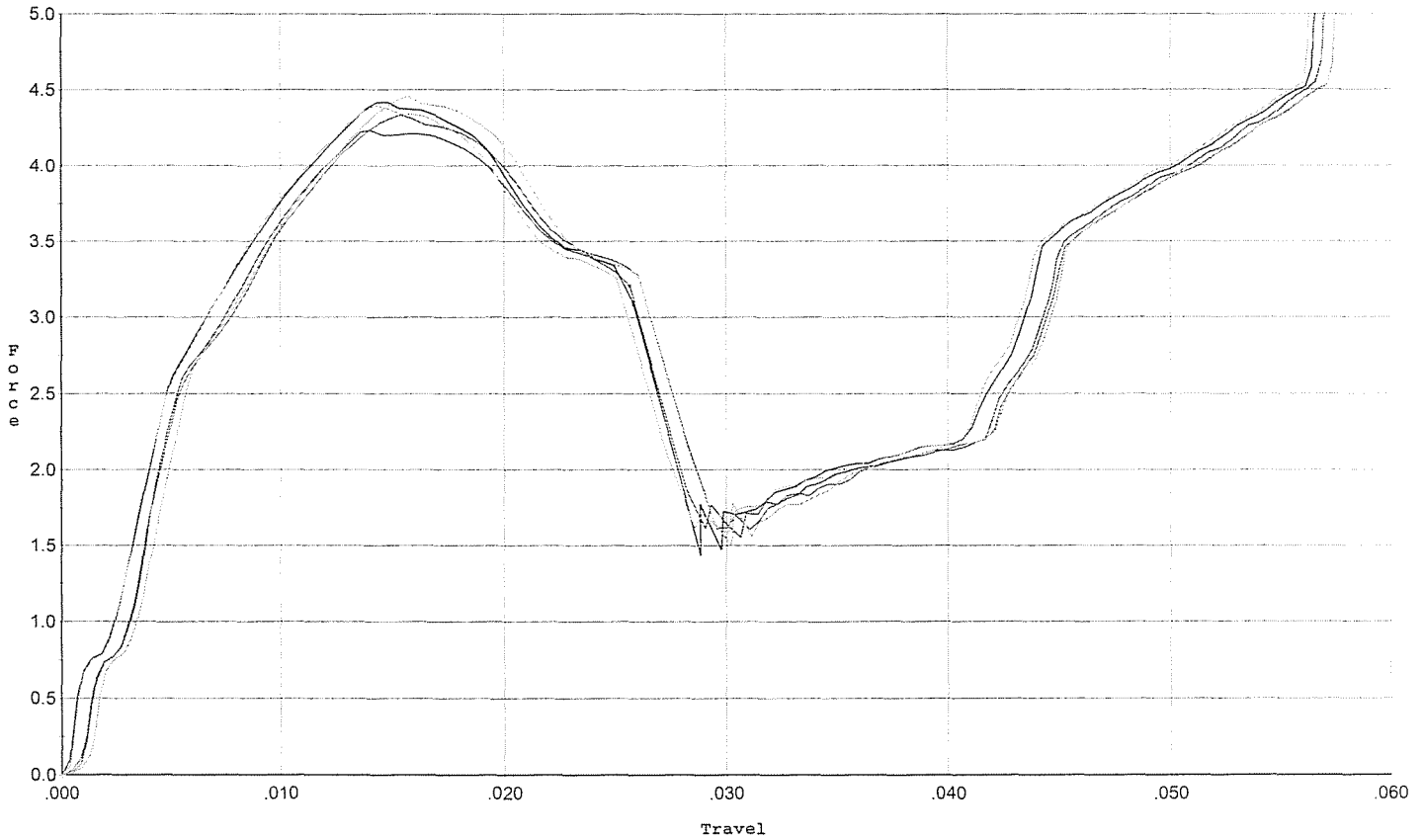
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.776	0.023	0.00	0.034	0.044		Set Trigger
2	2.776	0.024	0.00	0.032	0.047		Set Trigger
3	2.677	0.023	0.00	0.033	0.043		Set Trigger
4	2.618	0.023	0.00	0.033	0.042		Set Trigger
5	2.747	0.022	0.00	0.033	0.043		Set Trigger

A-2.71

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs +/- 1.0 lb for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.232	0.026	0.00	0.033	0.075		Set Trigger
2	4.418	0.026	0.00	0.033	0.078		Set Trigger
3	4.336	0.026	0.00	0.033	0.076		Set Trigger
4	4.395	0.025	0.00	0.033	0.075		Set Trigger
5	4.455	0.026	0.00	0.033	0.077		Set Trigger

A-4.36